

Date: Thursday, 1/17/2008 3:32:04 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HINGE BRACKET		
Job Number	36855			Part Number	D28571		
Estimate Number	10345			Drawing Number	D2857 REV B		
P.O. Number	:			Project Number	N/A		
This Issue	1/17/2008			Drawing Revision	B		
Prsht Rev.	NC			Material	:		
First Issue	1/1			Due Date	2/12/2008		
Previous Run	33942			Qty:	24		
Written By	:			Um:	Each		
Checked & Approved By	<u>DK</u> 08/02/12						
Comment	Est C 00.06.22 Removed P/O for powder coat EC						
	Est D 06.05.01 Added level 8 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"	
		Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s) Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B200001250) Batch <u>M105838</u>	
2.0	BAND SAW	BAND SAW	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36855		Part Number: D28571
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		ML 08/02/17 (26)
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble 2-Deburr any rough edges after tumbling		J.L 08/02/18
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.3		FL 08/02/19 (26)
8.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		08-02-20 (26)
9.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Gloss White (Ref. 4.3.5.1) per Dart(QSI) 005 4.3		M107005 (26)
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		M-1 08/02/20 (26)
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 50		8/2/21 50 (26)
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		08/02/22 (26)
Job Completion 		2008/02/21 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36855
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

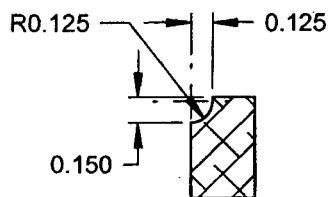
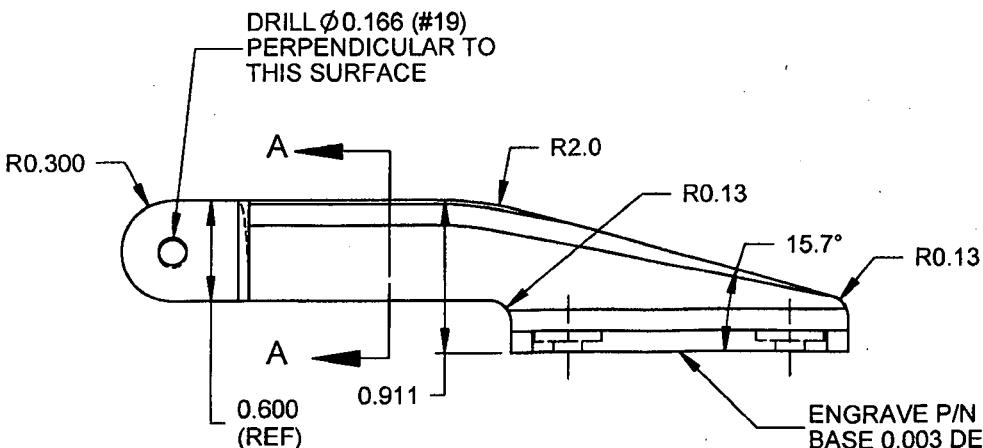
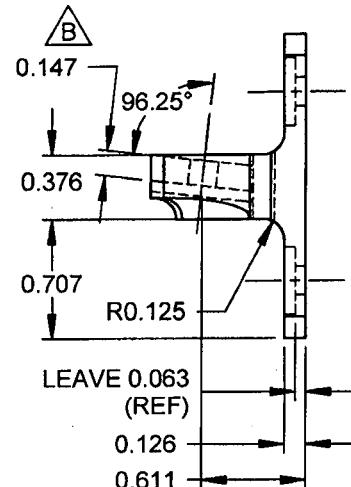
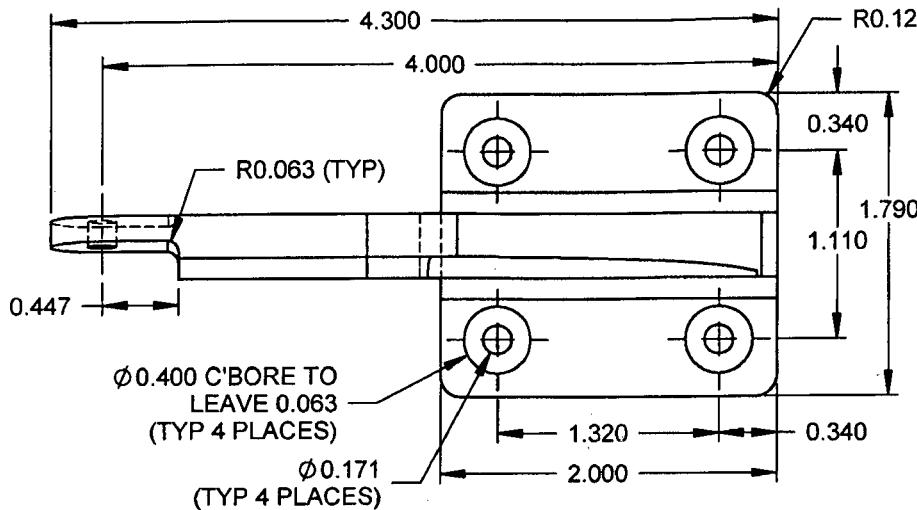
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.308	✓			
4.000	+/-0.010	4.006	✓			
0.340	+/-0.010	.340	✓			
1.110	+/-0.005	1.109	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.000	✓			
0.340	+/-0.010	.340	✓			
0.447	+/-0.010	.447				
Ø0.171	+0.005/-0.000	.174	✓			
0.147	+/-0.010	.145	✓			
0.376	+/-0.010	.376	✓			
0.126	+/-0.010	.132	✓			
0.063	+/-0.010	.072	✓			
Ø0.166	+0.005/-0.000	.161	✓			
0.911	+/-0.010	.911	✓			
0.600	+/-0.010	.599				
0.125	+/-0.010	.125	✓			
0.150	+/-0.010	.150	✓			

Measured by:	J.L	Audited by:	CML	Prototype Approval:	N/A
Date:	08/02/15	Date:	08/02/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

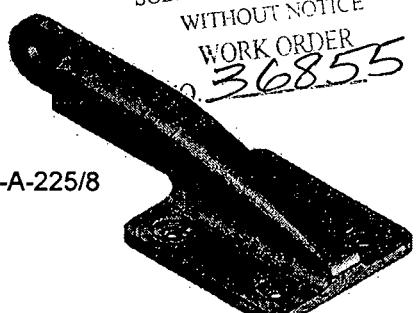
DART

DESIGN KE	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28		TITLE HINGE BRACKET	SCALE 1:1
REV A	DATE 98.12.14	DESCRIPTION NEW ISSUE	
REV B	DATE 06.08.28	DESCRIPTION ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06.10.13

SECTION A-A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36855

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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